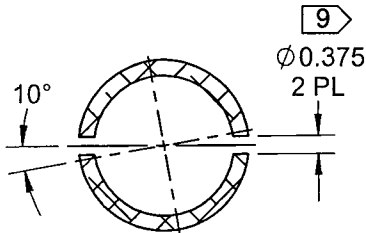
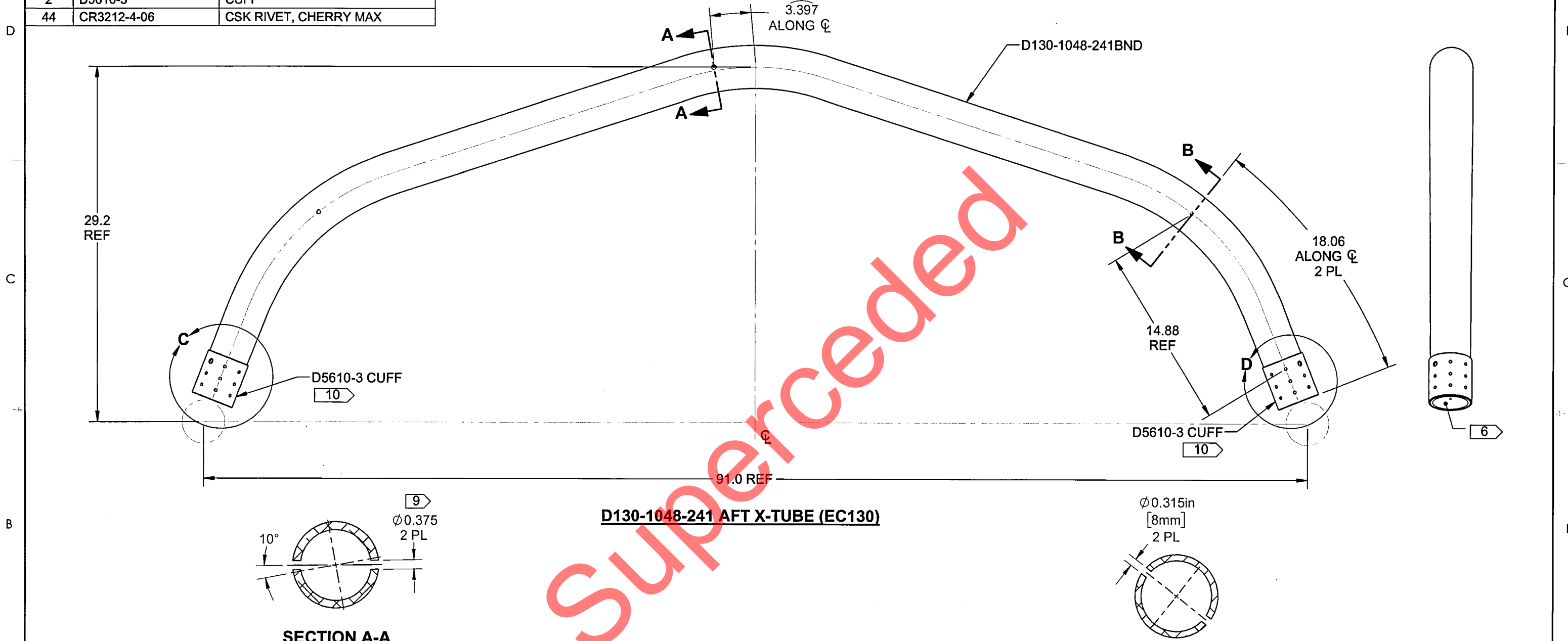
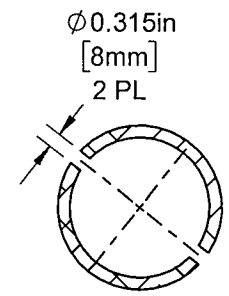


QTY -241	P/N	DESCRIPTION
X	D130-1048-241	AFT X-TUBE (EC130)
1	D130-1048-241BND	AFT X-TUBE (EC130)
2	D5610-3	CUFF
44	CR3212-4-06	CSK RIVET, CHERRY MAX



SECTION A-A  
SCALE 2X



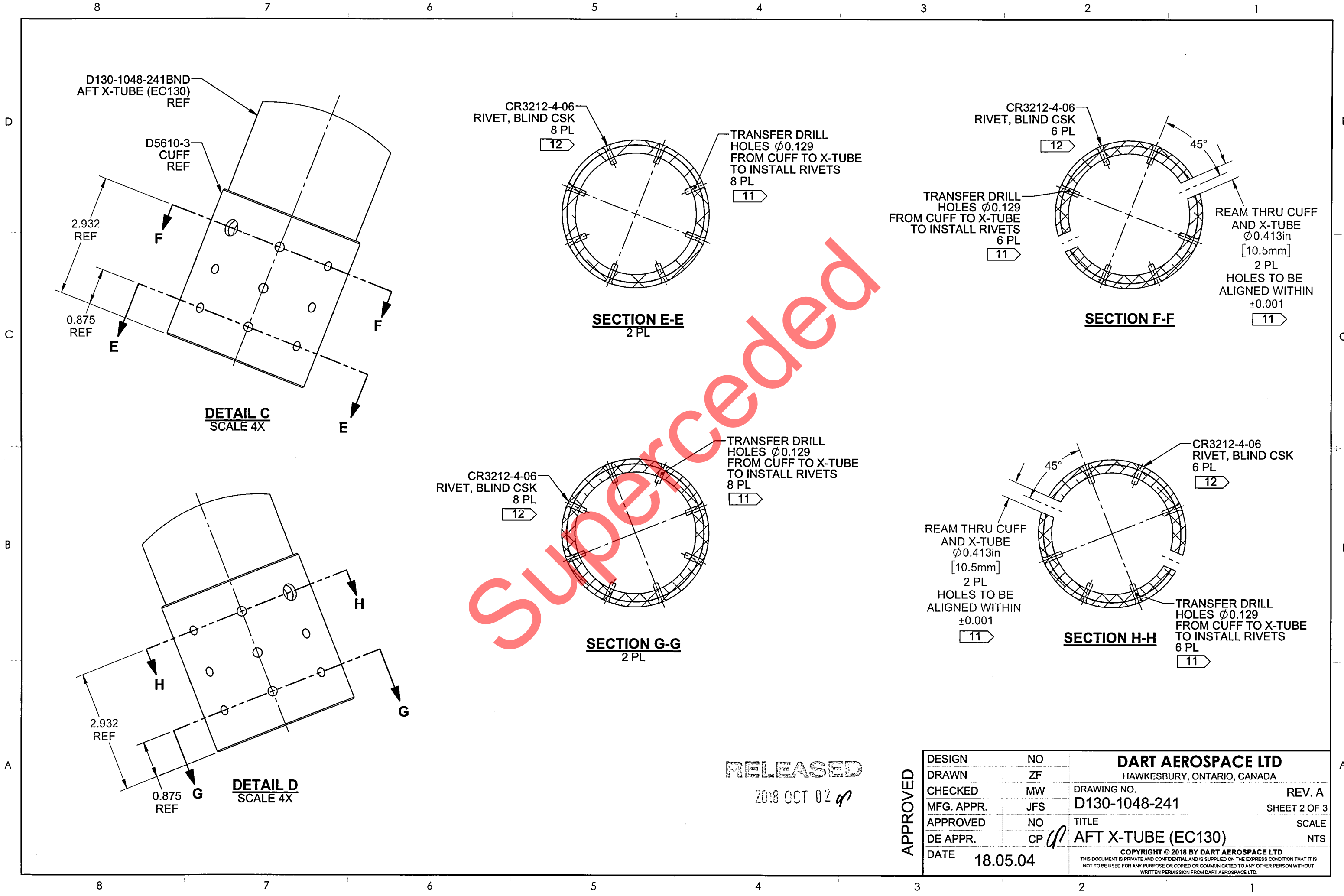
SECTION B-B  
SCALE 2X, 2 PL

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)  
PAINT OUTSIDE PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT)
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: SCRIBE DART P/N "D130-1048-241" AND S/N PER DART QSI 044 6.4 (VIBRATING STYLUS) ON INSIDE OF CUFF
  - 7) WEIGHT: 31.95lbs
  - 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, WRINKLES, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE
  - 9) MASK THESE HOLES PRIOR TO FINISH
  - 10) INSTALL D5610-3 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUFF AND CROSSTUBE. SEAL EDGES OF CUFFS TO ENSURE NO GAPS.
  - 11) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.
  - 12) WET INSTALL RIVETS WITH SEALANT.

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ECN 18-017

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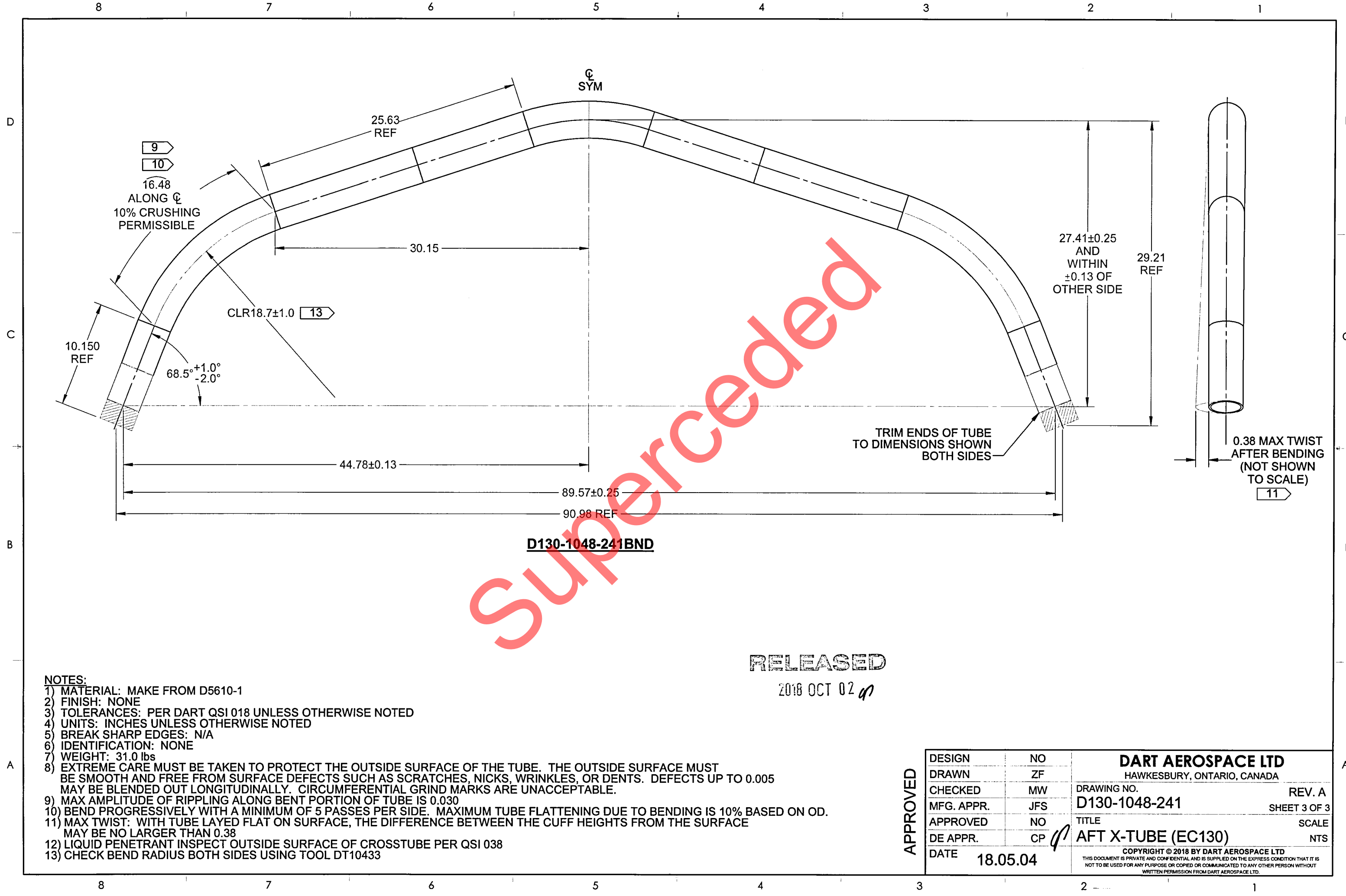
A	NEW ISSUE	ZF	18.05.04
REV.	DESCRIPTION	BY	DATE
DESIGN	NO	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. A
MFG. APPR.	JFS	D130-1048-241	SHEET 1 OF 3
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	AFT X-TUBE (EC130)	NTS
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DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MW	DRAWING NO.	REV. A
MFG. APPR.	JFS	D130-1048-241	SHEET 2 OF 3
APPROVED	NO	TITLE	SCALE
DE APPR.	CP <i>qp</i>	AFT X-TUBE (EC130)	NTS
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D130-1048-241BND

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2018 OCT 02

NOTES:

- 1) MATERIAL: MAKE FROM D5610-1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 31.0 lbs
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, WRINKLES, OR DENTS. DEFECTS UP TO 0.005 MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 9) MAX AMPLITUDE OF RIPPLING ALONG BENT PORTION OF TUBE IS 0.030
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES PER SIDE. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 10% BASED ON OD.
- 11) MAX TWIST: WITH TUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN THE CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.38
- 12) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038
- 13) CHECK BEND RADIUS BOTH SIDES USING TOOL DT10433

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DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MW	DRAWING NO.	REV. A
MFG. APPR.	JFS	D130-1048-241	SHEET 3 OF 3
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	AFT X-TUBE (EC130)	NTS
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